












Date: Tuesday, 11/22/2005 9:50:18 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : MOUNTING LUG	
Job Number : 24895A			
Estimate Number : 10817			
P.O. Number :		Part Number : D31753	
This Date : 11/22/2005 S.O. No. : N/A		Drawing Number : D3175 REV. A	
Prshw. : NC		Project Number : N/A	
First Date : N/A Type : SMALL /MED FAB		Drawing Revision : A	
Previous Run : 22409A		Material : N/A	
Written By : <u>See comment below</u>		Due Date : 12/15/2005 Qty: 4 Um: Each	
Checked & Approved By : <u>See comment below</u>			
Comment : Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF			
Additional Product			
Job Number: 			
245			
Step:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25"	
			
Comment: Qty.: 0.1860 f(s)/Unit Total : 0.7438 f(s) Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) Batch: <u>M17887</u>			
MS 05/11/28 4			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blanks: 2.125" x 1.250"			
MS 05/11/28 4			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA294 and Dwg D3175 Deburr and Tumble Identify as D3175-3			
MS 05/11/28 4			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
MS 05/11/28 4			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
EP 05/11/28 4			

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Job Number:



Step #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC/05-11-28/41

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

M 05 11 28 / 4

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 402

10 5 / 11 / 30 4

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

05/12/01

Job Completion



c2



[illegible][illegible]

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1000

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Rev  
A

Change  
New Issues

[illegible][illegible]

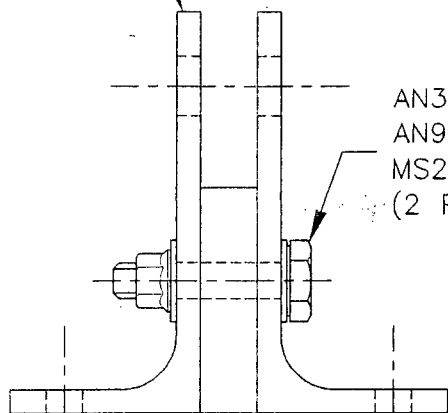
Approved
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CONTROLLED COPY



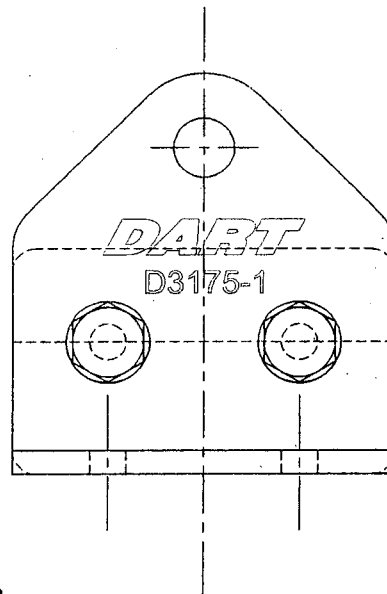
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	

D3175-1  
(2 PLACES)



AN3-7A BOLT (1)  
AN960JD10L WASHER (2)  
MS21042L3 NUT (1)  
(2 PLACES)

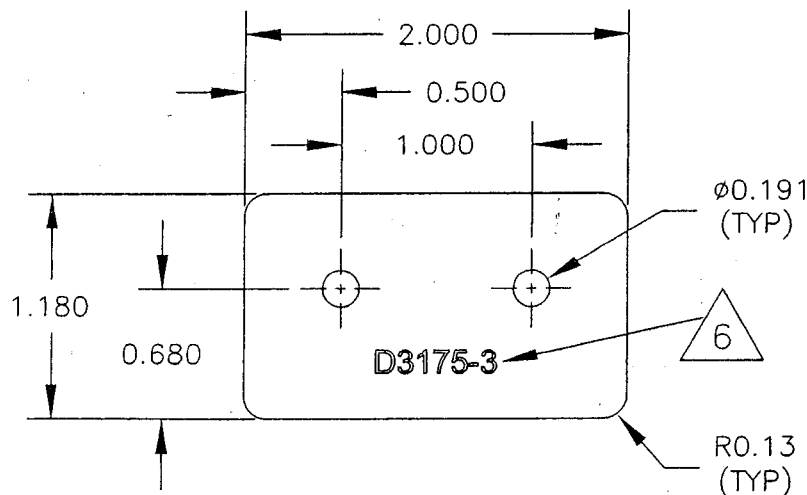
D3175-3



### D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)  
PER DART QSI 005 4.3

RELEASED  
02.12.03 *#*



### D3175-3 SPACER

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK  
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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